AMENDMENT NO. 1 JANUARY 2021

TO

IS 15524 : 2018 AUTOMOTIVE VEHICLES — RETREADING OF TYRES BY THE PRE-CURED PROCESS — SPECIFICATION

(First Revision)

(*Page* 7**,** *Table* 3) — Substitute the following for the existing table:

Table 3 Physical Properties for Bonding/Cushion Gum (Independently Curable)

(*Clause* A-2.2)

Sl No.	Test Parameters	Requirement	Method of Test, Ref to Part of IS 3400
(1)	(2)	(3)	(4)
i)	a) Appearance	The material shall have smooth finish and free from foreign material, ,cure bits, lumps and blisters, wrinkles and kinks	—
	b) Dimensions	Thickness 1.2 mm or as detailed earlier or as agreed upon	—
ii)	Specific gravity (*Max*)	1.13	(Part 9)
iii)	Scorch time, *Min* (t_5 at 138 ± 1°C) *Min* t_5 (Time for 5 units rise from minimum viscosity) at 138 ± 1°C, *Min*	3	ISO 289-2-1994
iv)	Optimum cure time (t_{90} at 138 ± 1°C), *Min* NOTE — Time must be related with O.C.T. of black vulcanising cement and as per the system of curing suggested by the manufacturer.	10-20	ISO 6502-1999

Table 3 (*Concluded*)

Sl No.	Test Parameters	Requirement	Method of Test, Ref to Part of IS 3400
(1)	(2)	(3)	(4)
v)	Hardness IRHD/Durometer, Shore-A	45 to 60	(Part 9)
vi)	Stress-Strain properties:		
	a) 300 percent modulus (kg/cm^2), *Min*	50	(Part 1)
	b) Tensile strength (kg/cm^2), *Min*	170	(Part 1)
	c) Elongation at break percent, *Min*	450	(Part 1)

(*Page* 7, *Table* 4) — Substitute the following for the existing table :

Table 4 Physical Properties for Vulcanising Cement/Solution

(*Clause* A-4.2)

Sl No.	Test Parameters	Requirement	Method of Test, Ref to Part of IS 3400	Annex
(1)	(2)	(3)	(4)	(5)
i)	Visual examination	The cement shall have uniform consistency and no sedimentation	—	—
ii)	Specific gravity, *Max*	1.13	(Part 9)	—
iii)	Drying : Touch dry time minimum at 25°C to 40°C and 70 RH, *Max*:			
	a) Spray application	10 to 20 min		
	b) Brush application	30 to 40 min		
iv)	Total solid content percent by mass, *Min:*			
	a) Spray application	8	A	
	b) Brush application	10		
v)	Cured pull test adhesion, (kgf/mm), *Min*	5/25	B	

(TED 07)

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